

Abstract:

These inventions intend to provide an improved method and apparatus for molding molds having no flask.

A match plate is put between an upper and a lower flask having intakes for foundry sand. An upper and a lower molding space are defined by inserting an upper and a lower squeeze means into openings of a pair of the upper and the lower flask having no match plate, and a pair of the upper and the lower flask and the match plate are rotated and moved so that they become perpendicular, and are moved so that the intakes of the flasks move upward.

The upper and the lower molding space are filled with the foundry sand. The foundry sand in the molding space is squeezed by squeezing means. A pair of the flasks and the match plate are rotated so that they become horizontal. Then the match plate is removed.

While the preceding processes are being carried out, if necessary the core is installed between the molds, the flasks are matched to each other, and the molds are removed from the pair of flasks.